

Work Order ID 62559

October 4, 2010 11:18:43 AM

Ship Oct-6



Page 1

Item ID: D3150-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 10/04/10 Start Qty: 12.00



Cust Item ID:

Required Date: 10/06/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3150

Rev C

100

0.00

B10-10-4

15



Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT AS PER DWG

DWG REV: C

PROG REV: C

304 .125

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00

B10-10-4



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Process Plan:

Date:

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

8/10/10/05

415

Memo

130



Small Fab

Small Fab

COUNTER SINK AS PER DWG

0.00

0.00

Memo

+ Debur

8/10/10/05 15

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

8/10/10/05

415

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D3150-1

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Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 10/04/10 Start Qty: 12.00



Cust Item ID:

Required Date: 10/06/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

Identify as per dwg & Stock Location: 7

0.00



Packaging

Memo

0.00

Packaging

10/14/10 *TS*

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/05 *ME*
10-10-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 4, 2010 11:18:41 AM

Page 1

Work Order ID: 62559

Parent Item: D3150-1

Parent Item Name: Guide



Start Date: 10/04/10

Required Date: 10/06/10

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-09-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	57.7523	0.0156	0.197053	5		
304/316 0.125 Sheet													



B10-10-4

Location

Loc Qty

Loc Code

MAT

57.7523

114799

57.7523

114799

15

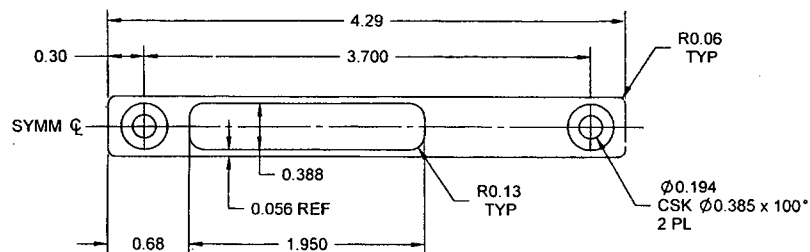
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3150-1 GUIDE

wlo 62559

RELEASED
2010-09-23
MP



NOTES:

- 1) MATERIAL: AISI 303/304 STAINLESS STEEL SHEET, 0.125 (11 GAUGE) THICK
ANNEALED 2B FINISH
MIL-S-5059
OR ASTM A240
OR ASME SA240
PER DART SPEC M303S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 0.05 lbs
- 8) REPLACES PREMIER P/N B30-23000-171

C	RE-DESIGN, CHANGE MATERIAL TO 303 OR 304 WAS NORMALIZED 4130N BAR (ZN A8-1)	RF	10.09.15
B	ADD PART MARKING & NORMALIZED	RF	04.10.18
A	NEW ISSUE	RF	02.04.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.09.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3150	REV. C
TITLE GUIDE	SHEET 1 OF 1 SCALE NTS

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